Dart Aerospace Ltd. Wednesday, 04/06/2008 8:41:01 AM Date: Linda Lacelle User: **Process Sheet** : SADDLE SPACER **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 39688 : 11062 **Estimate Number** : D2934 **Part Number** P.O. Number : D2934 REV B : 04/06/2008 **Drawing Number** S.O. No. : This Issue : N/A Project Number Prsht Rev. : NC : B : SMALL /MED FAB **Drawing Revision** First Issue : // Type : 37368 Material **Previous Run** 20 Um: Each : 04/06/2008 Qty: **Due Date** Written By Checked & Approved By New Issue EC Comment Est Rev:B Now 6061-T6 06-06-23 JLM Additional Product Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 .080 Sheet M6061T6S080 Comment: Qty.: 0.0334 sf(s)/Unit Total: 0.6678 sf(s)Material: 6061-T6 0.080" Thick Batch 104392 FLOW WATER JET 2.0 WATER JET **Comment: FLOW WATER JET** 1-Cut as per Dwg D2934 Dwg Rev:_ Prog Rev:_ 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 5.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1

Dart Aerospace Ltd

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No):	PAR #: Fault Category:	NCR: Ye	s No DQ	A:	Date: _	<u> </u>				
			QA:	N/C Close	d:	_ Date: _					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE		Description of NC		Verification	Anneaual	A						
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

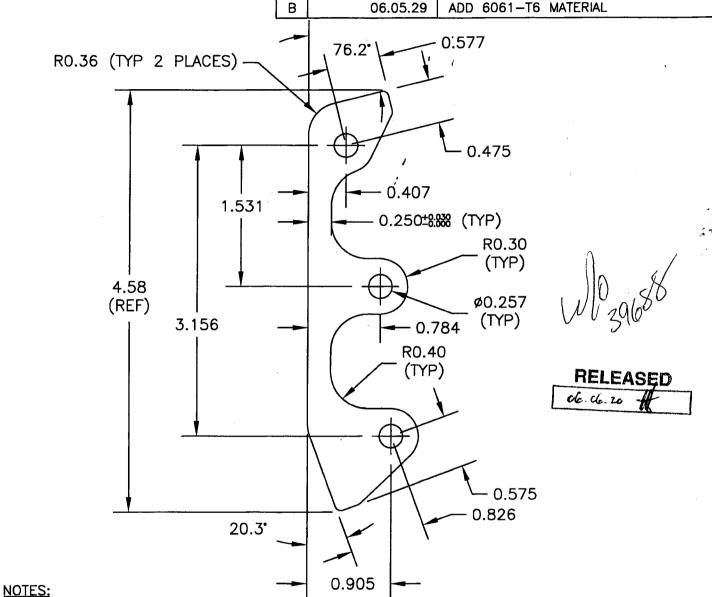
Wednesday, 04/06/2008 8:41:01 AM Date: Linda Lacelle User: **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2934 Job Number: 39688 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

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W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory: N	NCR: Yes No DQA: Date:				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries



DESIGN DRAWN BY DART AEROSPACE USA, INC. 14 PORT HADLOCK, WA REV. B DRAWING NO. CHECKED APPROVED SHEET 1 OF 1 D2934 SCALE DATE TILE SADDLE SPACER 06.05.29 99.11.02 **NEW ISSUE** Α



1) MATERIAL:

6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

ÒR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order: 34688
Description: SABOLE SPACER	Part Number: D 2934
Inspection Dwg: D 2934 Rev: R	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
—	4.006001	,758	*			
4.58	4- 030	4.593	*			
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Measured by:	R	Audited by:	1		Prototype Approval:	NA
Date:	9-6-4	Date:		1409080	Date:	1_
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Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

